

Date: Thursday, 02/04/2009 2:25:26 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PAINTED HINGE
Job Number	: 46839		
Estimate Number	: 10989		
P.O. Number	:	Part Number	: D2569
This Issue	: 02/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2569 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 26909	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>JUD 09.04.02</u>	Due Date	: 24/04/2009
Comment	: Est. D 01.12.17 Changed process EC	Qty:	6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MS2025737200	Piano Hinge
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Piano Hinge

Pick:

Qty Part number Description Batch

1 MS20257-3-7200 Hinge

M/11072

2.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATINGPowder Coat White (Ref 4.3.5.1) as per QSI 005 4.3 M/110939

Note: Advise that hinges are to be broken back and forth immediately after powder coating to ensure free mobility of hinge.

START TIME:

3:55

OVEN TEMPERATURE:

400°

FINISH TIME:

11:25BR 09-04-21(6)

3.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSIONFL 09/04/22 (6)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: CAPC 9/4/22 (6)Ben

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PAINTED HINGE

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/23 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

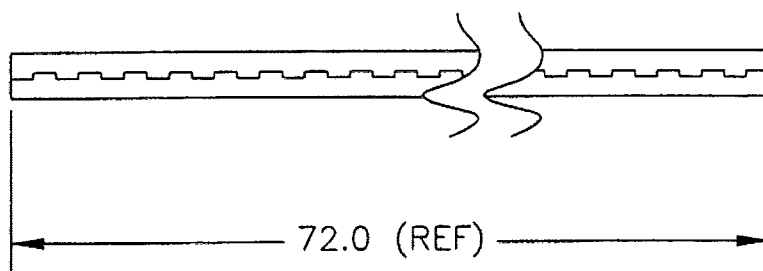
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>HA</i>	DRAWING NO. D2569	REV. B SHEET 1 OF 1
DATE 99.01.05		TITLE HINGE	SCALE 1:4
A	96.06.24	NEW ISSUE	
B	99.01.05	ADDED MS20257-3-7200 AND P/C REMOVED HOLE PATTERN	

RELEASED
99.01.21 *KE*



NOTES:

- 1) MAKE FROM MS20257-3-7200
- 2) POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ENSURE HINGE MOVEMENT IS MAINTAINED IMMEDIATELY AFTER POWDER COAT
- 4) USE 0.040 LOCKWIRE TO SECURE HINGE PIN AT BOTH ENDS
(USE #60 DRILL FOR LOCKWIRE HOLE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *46839*